

Date: Wednesday, 3/26/2008 9:53:59 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	LATCH ASSEMBLY		
Job Number	38174					
Estimate Number	10303					
P.O. Number	:		Part Number	D2586		
This Issue	: 3/26/2008	S.O. No. :	Drawing Number	D2586 REV D		
Prsht Rev.	: NC		Project Number	N/A		
First Issue	: / /	Type : PURCHASED PARTS	Drawing Revision	D		
Previous Run	: 36854		Material	:		
Written By	:		Due Date	: 4/4/2008	Qty:	100 Um: Each
Checked & Approved By	JD 08.3.27					
Comment	Est	E 02.01.31	Added Inspect level 21 NG			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6017

C408/03/28

Possible Supplier: Southco, P/N: C2-32-25

100

Certification Required

2.0	C23225	DOOR LATCH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

DOOR LATCH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

1-Receive and inspect for transit damage

R8/17 100

2-Attach certification

3-Stock Keys as: C2-32-25 Keys

4-Discard hardware

4.0	QC5	INSPECT WORK TO CURRENT STEP
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counts

Comment: INSPECT WORK TO CURRENT STEP

C408/04/07 (NO)

5.0	D30157	Lock Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Lock Nut

Pick:

Qty

Part Number

Description

Batch

1

D30157

Lock Nut

B36930

E408/04/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: * Wednesday, 3/26/2008 9:53:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 38174

Part Number: D2586

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Hole to 0.191"

2-Counterface as per Dwg D2586

3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.

E Bos/04/09 (100)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

C 08/04/09 (100)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *St223*

F - Syls (100)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09 AF

Job Completion



-MF

08-04-09

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

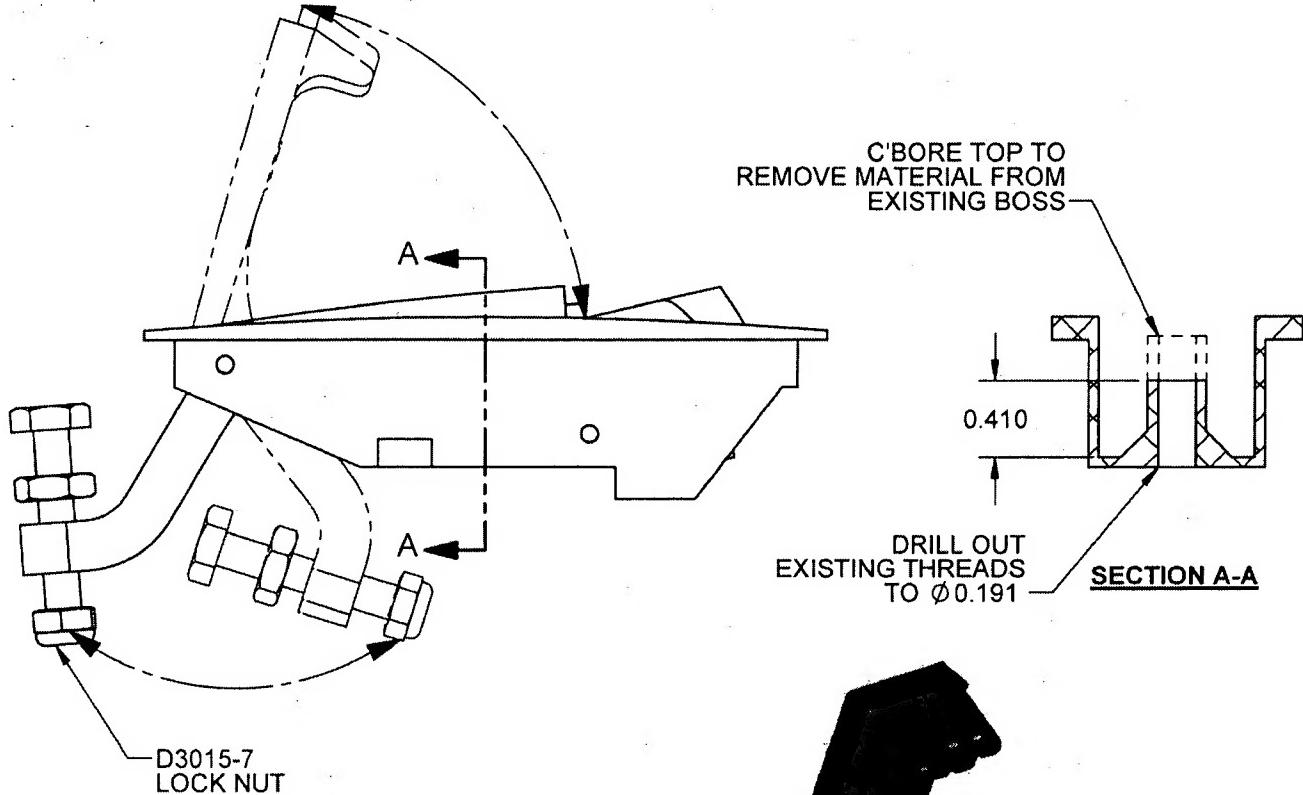
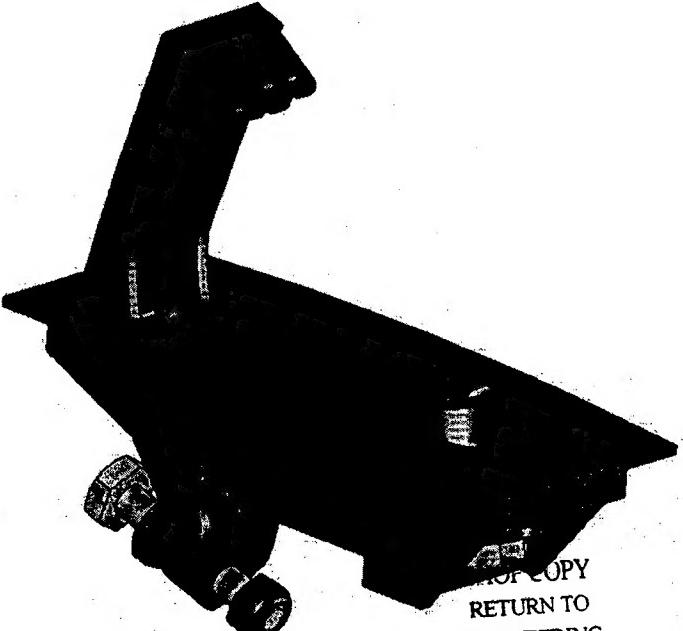
NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D2586
DATE 06.10.19		REV. D SHEET 1 OF 1 TITLE DOOR LATCH SCALE 1:1

RELEASED
(6.12.22)

REV	DATE	DESCRIPTION
A	96.07.15	NEW ISSUE
B	97.07.23	CHANGED C'BORE DEPTH
C	97.09.03	REVISED C'BORE DEPTH
D	06.10.19	ADD D3015-7 P/N; UPDATE DRAWING

**D2586 DOOR LATCH****NOTES:**

- 1) MAKE FROM SOUTHCOP P/N: C2-32-25
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS
OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38174

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T.C.H. Sales Inc.
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Trans Continental Hardware
10552 King William Drive
Dallas, TX 75220

1-800-465-6281
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CERTIFICATE OF COMPLIANCE

Date: 04 - 04 - 2008

Customer Name DART AEROSPACE LTD

Customer P.O. No.: 6017 TCH Order No.: 80291

Invoice No.: 97823 Date shipped: 04 - 04 - 2008

TCH Part No.: 555-C23225

Item Description:

(

This is to certify that the items identified herein have been produced in accordance with applicable instructions and or specifications, drawings, approved samples and/or other descriptions set forth in the Purchase Order.

Signature:

A handwritten signature, appearing to read "John", is written over a horizontal line.

Title:

Supervisor



T.C.H. Sales Inc.
40 Emblem Court,
Toronto, Ont. Canada,
M1S 1B1

T.C.H. Sales Inc. confirms that substances regulated by the EU Directive 2002/95/EC "on the restriction of the use of certain hazardous substances in electrical and electronic equipment" are not intentionally used in parts listed below.

These hazardous substances include:

- Lead
- Cadmium
- Chromium (Vi)
- Mercury
- Polybrominated Biphenyls
- Polybrominated Diphenylethers

Specifically, Part Numbers:

555 - C2325

These part numbers do not contain any of the above-mentioned hazardous substances.

Customer P.O. # 6017

TCH Order # 80291

Date Shipped 64 - 64 - 2008

Signature: M.R.

Title: Supervisor

T.C.H. Sales Inc. 40 Emblem Court, Toronto, Ont. Canada, M1S 1B1 tel (800) 465-6281, fax (416) 299-3255

Trans Continental Hardware Inc. 1370 William St., Buffalo, New York, 14206 tel (800) 465-6281, fax (716) 892-4302

Trans Continental Hardware Inc. 10552 King William Drive, Dallas, Texas, 75220 tel (800) 824-1556, fax (972) 556-9552

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(Foam Division)

